

Date: Thursday, 04/09/2008 1:23:19 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: TUBE ASSEMBLY 25"		
Job Number	: 41827			Part Number	: D3298001		
Estimate Number	: 11190			Drawing Number	: D3298 REV A2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/09/2008 S.O. No. :			Drawing Revision	: A2		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 30/09/2008 Qty: 6 Um: Each		
Previous Run	: 39648						
Written By	:						
Checked & Approved By	: JUD 08.9.09						
Comment	: Est A04.09.02 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W035	6061-T6 RD Tube .375 x.035W	
		Comment: Qty.: 2.1875 f(s)/Unit Total : 13.1248 f(s) Cut tube to length as per Dwg D3298 Material: 6061-T6 (WW-T-700/6) tubing Ø0.375" x 0.035" wall (M6061T6T0.375W.035) Identify as D3298-001 Batch: 104921	FF 08/09/25
2.0	MS208196D	Sleeve	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) Sleeve Pick: Qty Part Number Description Batch 1 MS20819-6D Sleeve 1107799	FF 08/09/25
3.0	AN8186D	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) Coupling Nut Pick: Qty Part Number Description Batch 1 AN818-6D Nut 1107756	FF 08/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3298001

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend tube as per template D3298-001T1 & Dwg D3298

Flare end as per Dwg D3298.

Ensure that sleeves and coupling are installed first

FF 08/09/25

(6)

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/05 (46)

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 195

8/9/25

6x

5d

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/30/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3298	SHEET 1 OF 7
DATE		TITLE	SCALE
04.07.06		TUBE ASSEMBLIES	NTS
A	04.07.06	NEW ISSUE	
A1	04.07.06 04.11.30	CORRECT VIEW D3298-003; 16.50 WAS 15.75	
A2	04.07.06 05.05.06	FOR D3298-001/-003 16.00 WAS 16.50	

RELEASED
04.09.09

P/N	TEMPLATE	CUT LENGTH OF TUBE	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL
D3298-001	D3298-001T1	25.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-003	D3298-003T1	27.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-005	D3298-005T1	23.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-007	D3298-007T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-009	D3298-009T1	6.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-011	D3298-011T1	8.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-013	D3298-013T1	10.00	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)
D3298-015	D3298-015T1	14.00	1	1	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W (WW-T-700/6)

Notes:

- (1) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (2) TUBES TO BE FLARED 37° TO MATE WITH FITTINGS MADE TO MS33514.
- (3) ENSURE SEAMLESS TUBING IS USED.
- (4) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- (6) ALL DIMENSIONS ARE IN INCHES
- (7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

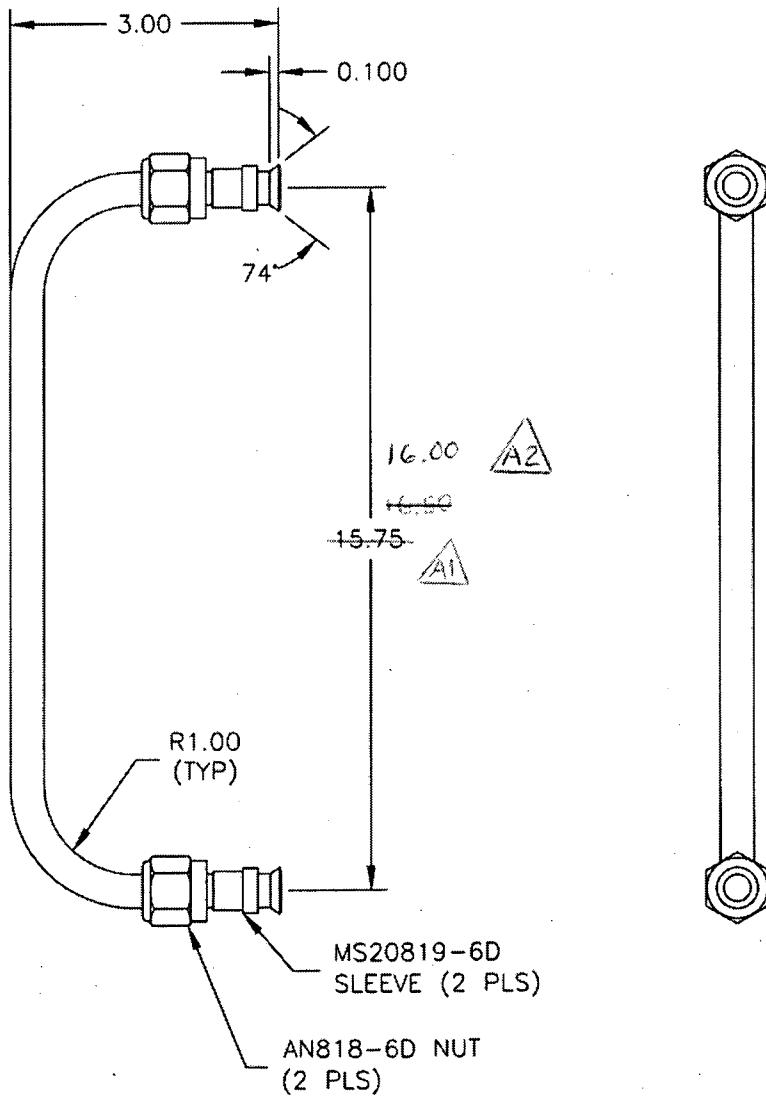
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DATE 04.07.06	TITLE TUBE ASSEMBLIES	SCALE NTS	

RELEASED
04.09.09 *ff***D3298-001**

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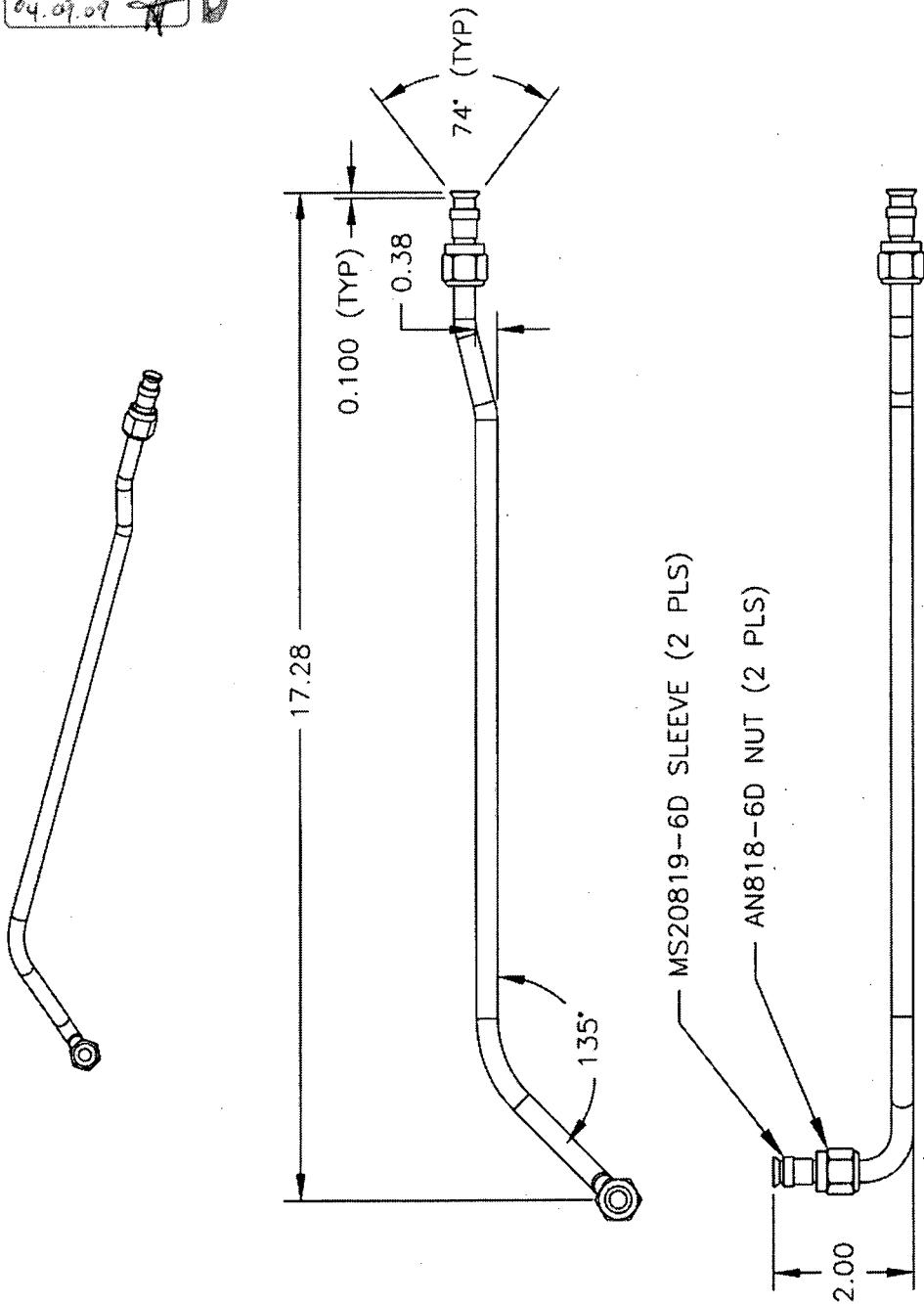
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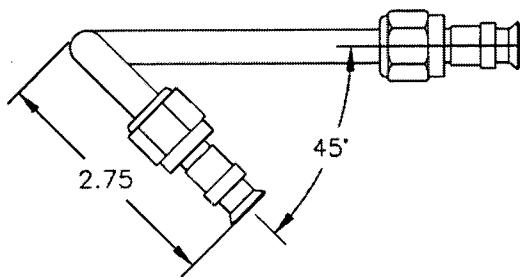
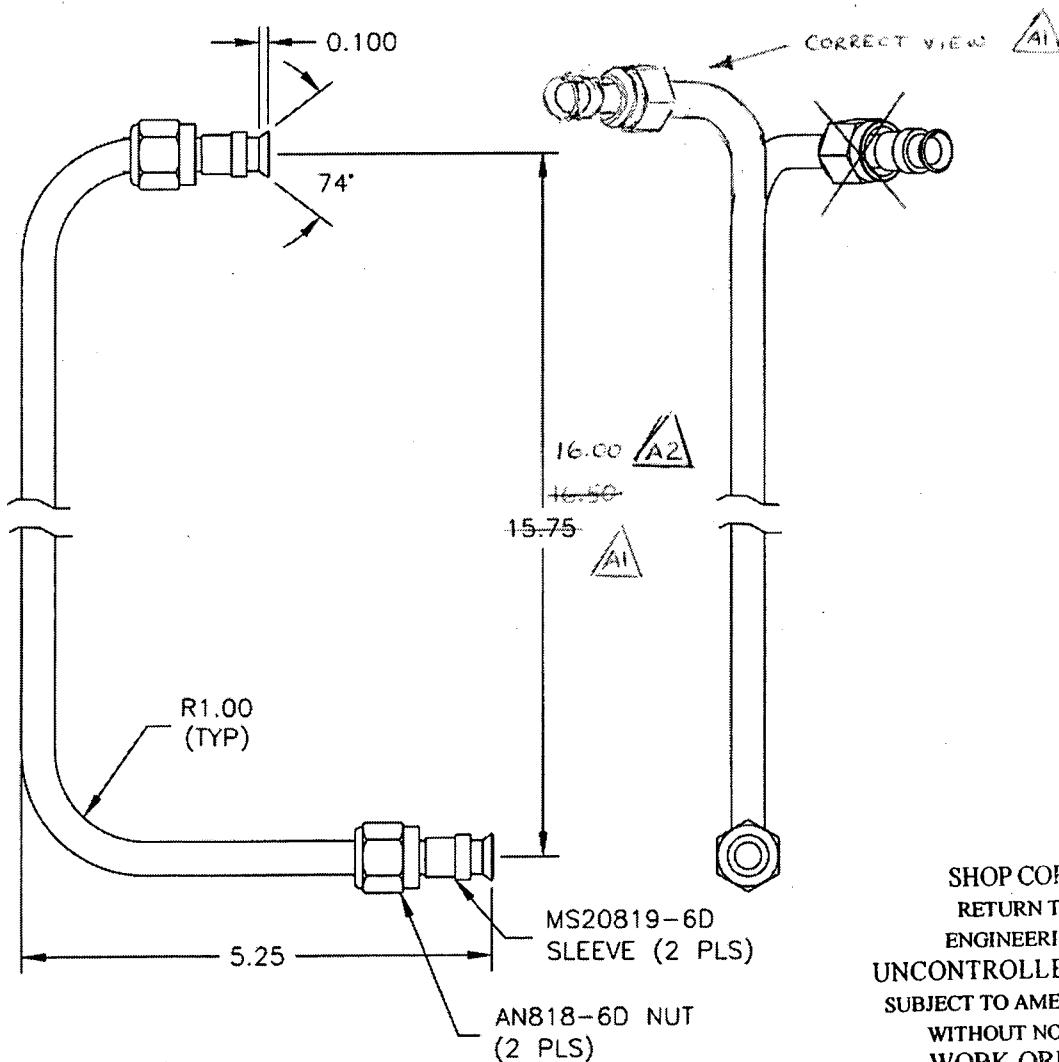
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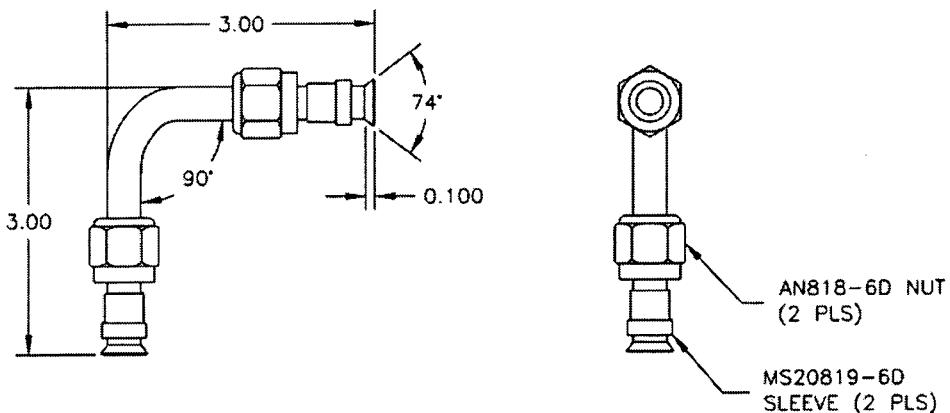
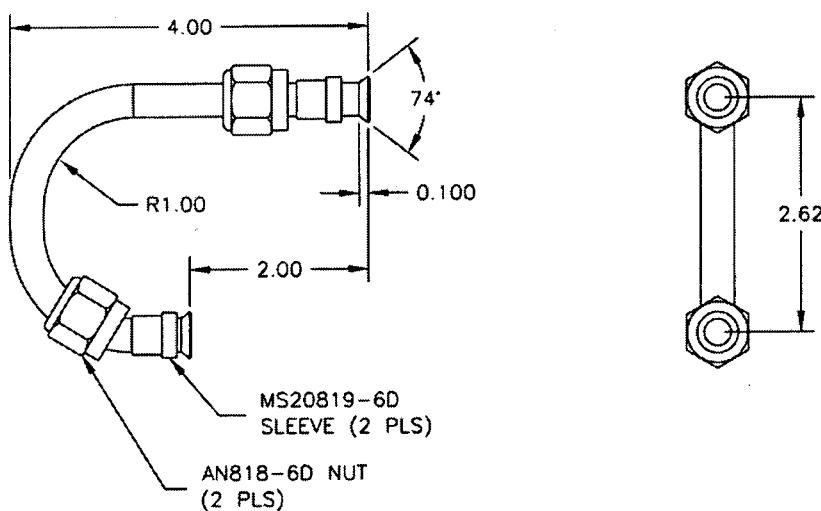
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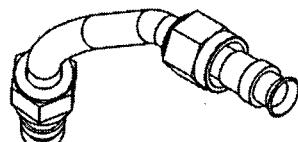
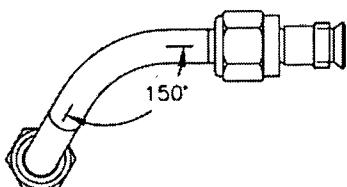
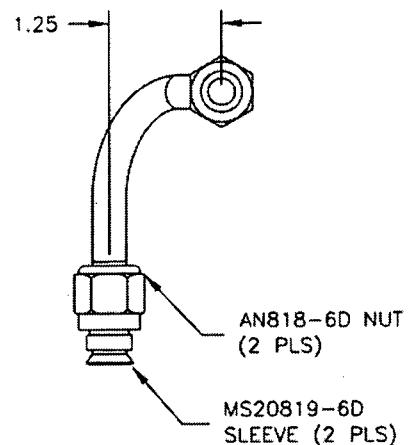
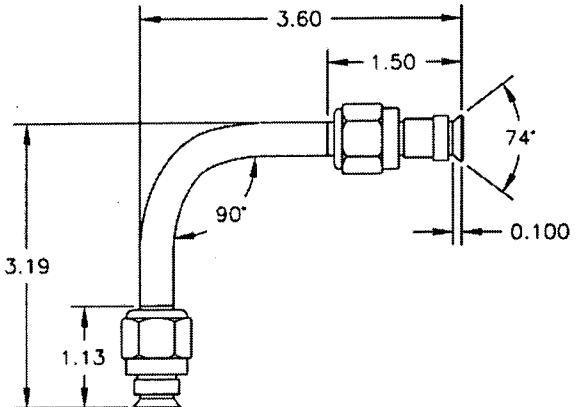
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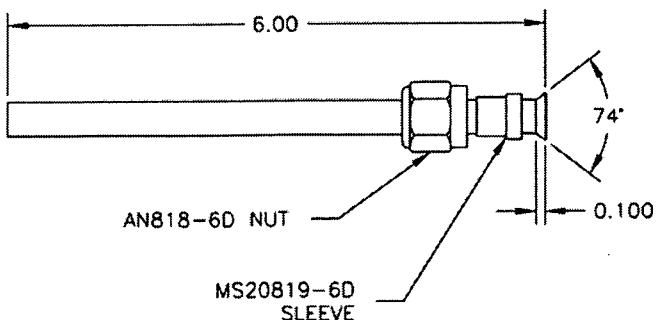
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D3298-011



D3298-009

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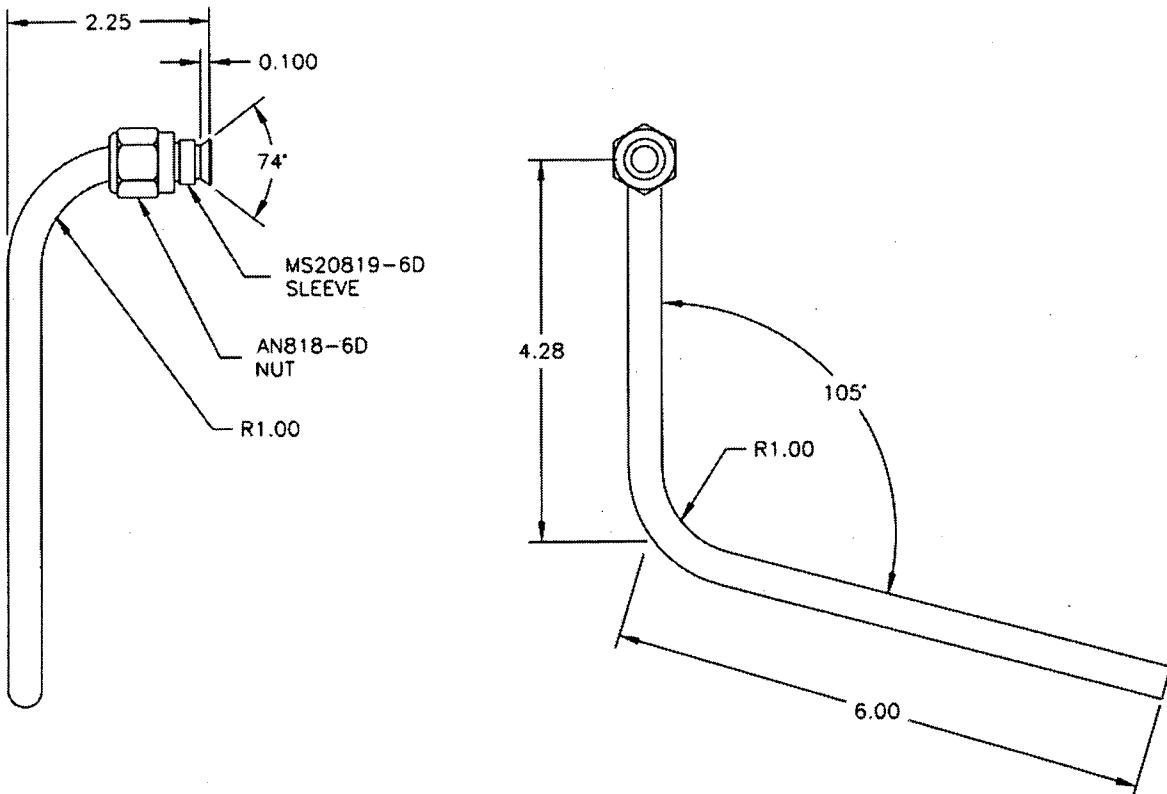
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D3298-015

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